

Work Order ID 59966

Tuesday, June 22, 2010 9:58:40 AM



Page 1

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop



Start Date: 6/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *PH*

Date: *10-6-22* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG0021

I (ED) put red labels on steps
5

cinocapex

H. J. for BG 10/07/10

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

110-07-06

10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R ☐ Aluminum Rod *M112860*
M114242

3-Grind End Plate flush

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

⑩ 10 007.06

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/06

⑩ 10 441

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-07-08

10 10

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BR 10712

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M112860

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10 07.14

10

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Hand Finishing

*10

BE 10/07/15

8-20-07-15

10
44

10 BR 10-7-21.

W/O:		WORK ORDER CHANGES						
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



Powdercoat
Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

M 114841

0.00

Memo

START TIME: *1:00*
OVEN TEMPERATURE: *320°*
FINISH TIME: *1:30*

0.00

10

BL 10-7-21

230



HandFinish
Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch *111144300*

Memo

0.00

=> 10/07/21

10WH

240



QC
Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

8/10/02/22

410
LM

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-7-16

5/100

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/6/12

40
41

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: _____

2008

10-7

235

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/26 *[Signature]*
MF
10-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, June 22, 2010 9:58:44 AM

Page 1

Work Order ID: 59966

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 End Plate		Manufactured	No			110	Each	3.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	359596	3				8			
					57926	3				2			
D3219-1 Plate		Manufactured	No			110	Each	113.0000	2	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		113							
					58550	17				17			
					59597	96				3			
D3272-1 Step		Manufactured	No			110	Each	10.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA	359970	10				10			
					59952	10							
					359970								

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Page 2

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3065-041 Manufactured No

180 Each

14.0000

1

10



Step Leg Assembly Hi



10-07-13

Location

Loc Qty

Loc Code

WA 359678
58160
58536

14
1
13

6
4

D3066-1 Manufactured No

180 Each

77.0000

2

20



Spacer



10-07-13

Location

Loc Qty

Loc Code

WA 360194
58540

77
77

20

D3067-1 Manufactured No

180 Each

3.0000

1

10



End Plate



10-07-13

Location

Loc Qty

Loc Code

WA 359596
57926

3
3

10

MS20600-AD4W4 Purchased No

180 Each

959.0000

16

160



Rivets



10-07-13

Location

Loc Qty

Loc Code

ST321

959
62
11
2
884

113368
114181
114718
114935

160

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Shop Packet Print

Page 2

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A Purchased No 250 Each 17.0000



Bolt

17.0000



MI15016 10-7-198

Location

Loc Qty

Loc Code

ST353

17

114784

17

AN4-13A Purchased No 250 Each 478.0000



Bolt

478.0000



MI109222 10-7-198

Location

Loc Qty

Loc Code

ST357

478

114941

478

AN5-36A Purchased No 250 Each 269.0000



Bolt

269.0000



MI13288 10-7-198

Location

Loc Qty

Loc Code

ST341

269

114292

19

114784

50

114941

200

AN960JD10 Purchased No 250 Each 0.0000



Washer

0.0000



MI13288 10-7-198

AN960JD416 Purchased No 250 Each 6.0000



Washer

6.0000



MI15000 10-7-198

Location

Loc Qty

Loc Code

ST357

6

107939

6

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Shop Packet Print

Page 3

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Start Qty: 10.00

Required Qty: 10.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000



Washer

D2230-3

Manufactured No

250 Each

179.0000



Lug

Location

Loc Qty

Loc Code

ST476

179

55452

2

59115

17

59418

160

D2618

Manufactured No

250 Each

25.0000



Bushing

Location

Loc Qty

Loc Code

ST020

25

56892

1

57829

24

D2856-400

Manufactured No

250

182.7820



Abraison Strip

Location

Loc Qty

Loc Code

ST403

182.782

56626

182.782

D3235-1

Manufactured No

250

Each

103.0000



Mounting Lug

Location

Loc Qty

Loc Code

ST471

103

58717

43

59125

60

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Page 4

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Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250 Each

60.0000 1

10



Support Assembly

Location

Loc Qty

Loc Code

ST471

60

59633

60

MS21042L3

Purchased No

250 Each

3,085.000 2

10



Nut

Location

Loc Qty

Loc Code

ST300

3085

114523

585

114718

500

114784

2000

MS21042L4

Purchased No

250 Each

3,046.000 8

80



Nut

Location

Loc Qty

Loc Code

ST300

3046

113422

68

114523

28

114718

950

114784

2000

MS21042L5

Purchased No

250 Each

681.0000 2

20



Nut

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

181

114449

181

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DART

DESIGN <i>90</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07 06 04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 59964

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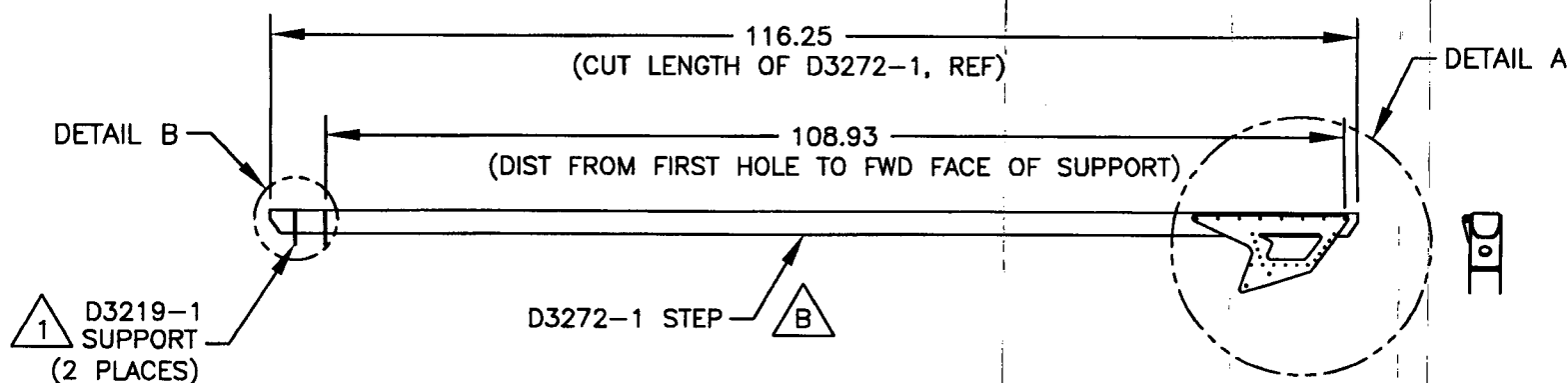
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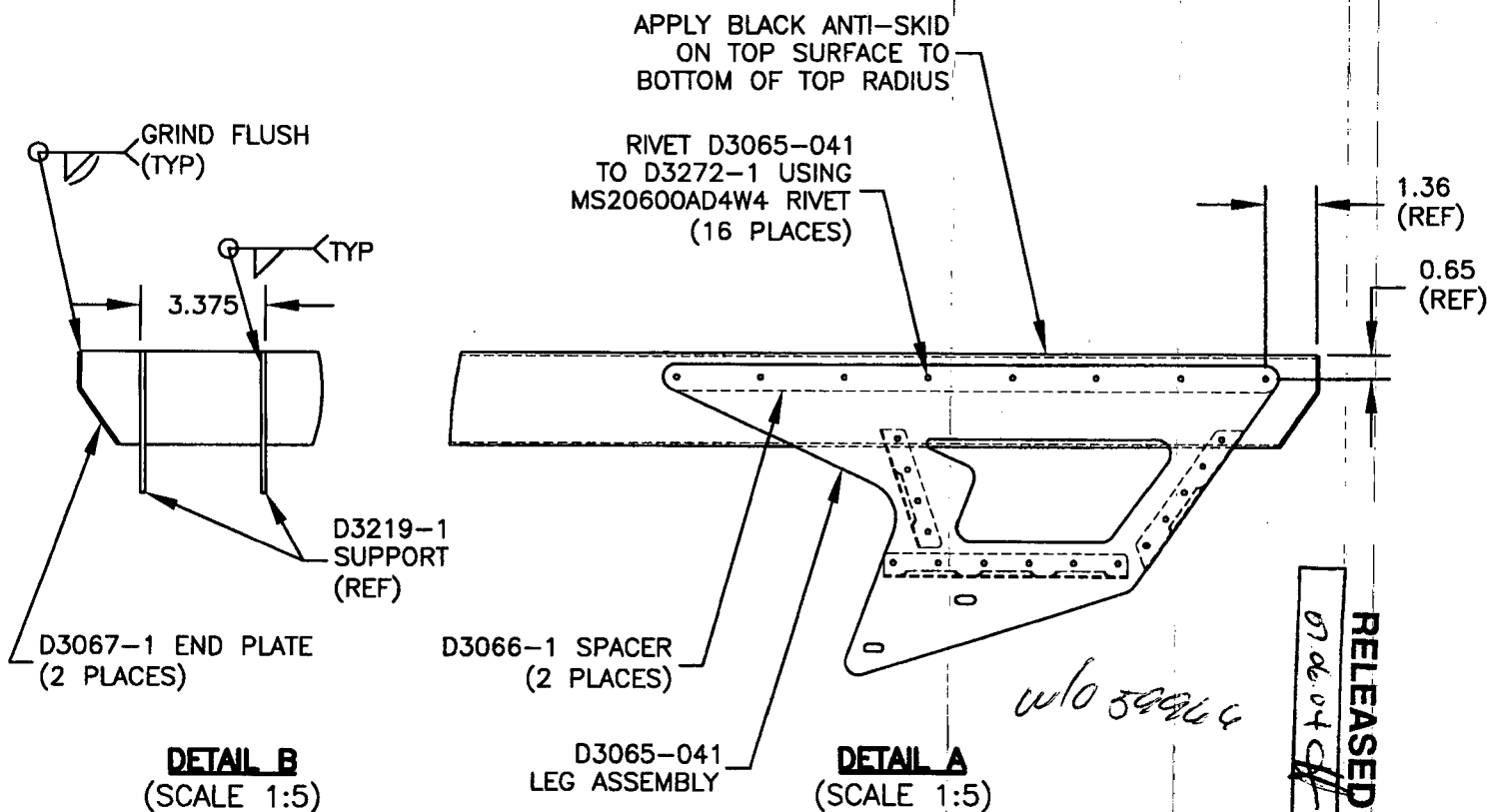
NOTE: Date & initial all entries

DART

DESIGN	q	DRAWN BY		DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA	
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3	SCALE
			STEP ASSEMBLY, HI LONG		1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

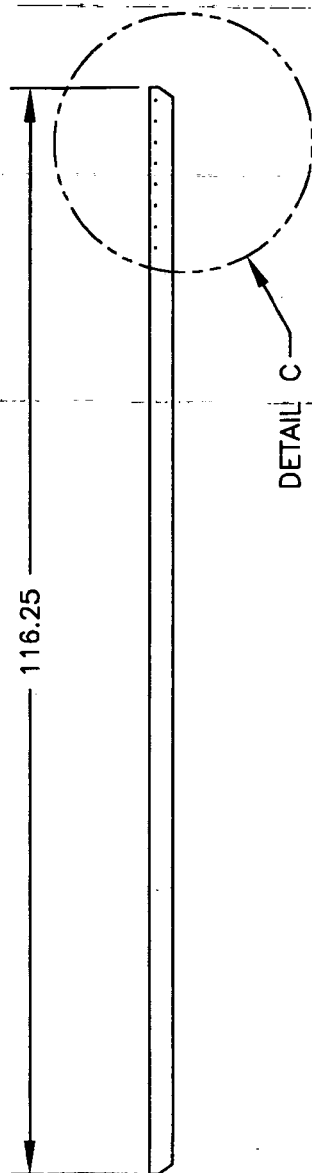
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

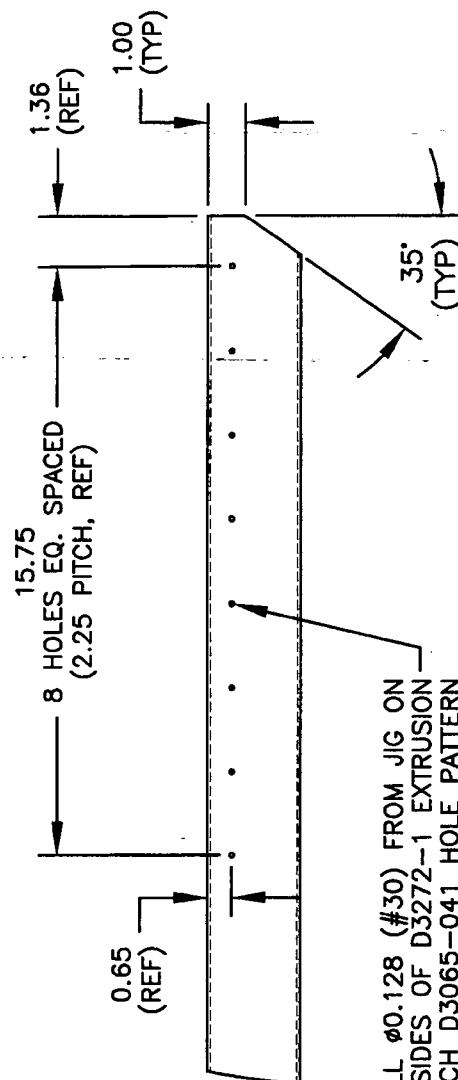
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

W/O 59964

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.